

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020758**Date Inspected:** 20-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Bike Path, Suspender Bracket**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Liu Huajie.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Deck Plate

PCMK: DP3174

Weld Number: 018

Welder: 037780

WPS-B-P-2212-TC-U4b-FCM-1

Component: Deck Plate

PCMK: DP3174

Weld Number: 018

Welder: 066480

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WPS-B-P-2212-TC-U4b-FCM-1

Component: Deck Plate

PCMK: DP3162

Weld Number: 247

Welder: 066416

WPS-B-P-2212-TC-U4b-FCM-1

Component: Deck Plate

PCMK: DP3159

Weld Number: 395

Welder: 044824

WPS-B-P-2232-TC-U4b-FCM-1

Component: Deck Plate

PCMK: DP3160

Weld Number: 380

Welder: 044824

WPS-B-P-2232-TC-U4b-FCM-1

Component: Longitudinal Diaphragm

PCMK: SEG3019Z

Weld Number: 007

Welder: 037932

WPS-B-P-2214-TC-U5b-FCM-1

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Shielded Metal Arc Welding (SMAW) and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Suspender Bracket

PCMK: SB027-110

Weld Number: 003, 004

Welder: 062752

WPS-B-T-2231-ESAB

WPS-B-T-2233-ESAB

Component: Bike Path

PCMK: BK005A2-002

Weld Number: 017

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Welder: 050082

WPS-B-P-2211-PLUG

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
